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C45-3-6

Job Sheet 191777



Part No: C45-3-6

Job Qty: 8 pcs

Part Name: Latch



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/8/19

Job Tracking No:

Due Date: 4/30/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: C45-3-6 rev.10 IPP REV:A 18.02.06 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	8 pcs	4/30/19	4/30/19	0.00	0.40	Bandsaw - 1		JBD 19/3/25
120	NV5000 - 1 - B4B	8 pcs	4/30/19	4/30/19	0.00	4.00	NV5000 - 1 - B4B		" "
							NV5000 - 2 - B4B		
130	QC 2	8 pcs	4/30/19	4/30/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

DAS
65
9-89

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140 QC 8	8 pcs	4/30/19	0.00 0.00	QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	11 11
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	D.A. 19-04-06
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
150 Packaging 3-2 - Stock - B4B	8 pcs	4/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	

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				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAG
160 QC 21 - FG	8 pcs	4/30/19	0.00 0.00	QC 21 - FG - 21	21 APR 08 2019
				QC 21 - FG - 70	9-88 APR 08 2019
				QC 21 - SA - 53	

Part Op **100** - (Bandsaw) CUT BLANK AT 1.825"

Descriptions: **120** - (MORI SEIKI VERTICAL MACHINE #1) 1-Machine as per folio FB814 FOLIO REV: AA DWG REV: 10 2-Debur

130 - (QC2- Inspect parts off machine FAI/FAIB)1-Engrave Batch number as required Using Marktronic engraver as per DWG.

140 - (QC8- Inspect parts - second check)

150 - Identify as per dwg & Stock Location: _____)Identify and Stock

160 - QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.250X2.000	17-4 SS Bar 1.250 x 2.00	1.3333 ft (.16666 ea)	100-Bandsaw - 1	5158304

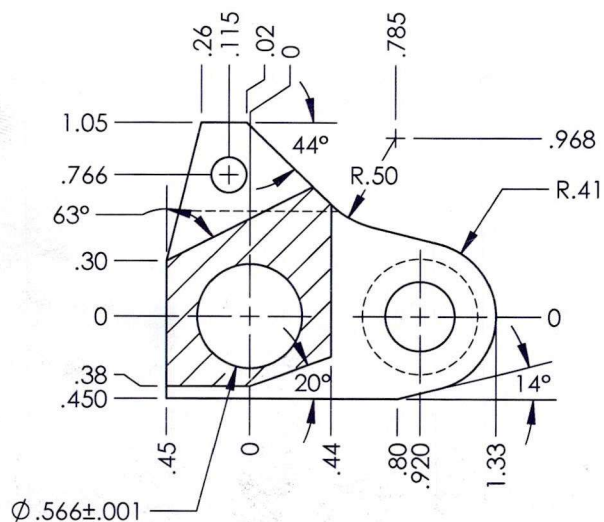
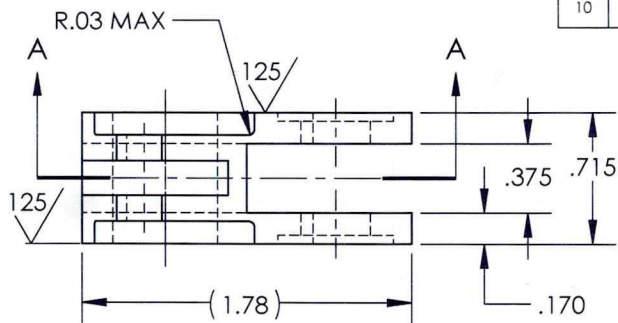
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-B1.250X2.000	1	25	0

Part Specifications
Specifications could not be found.

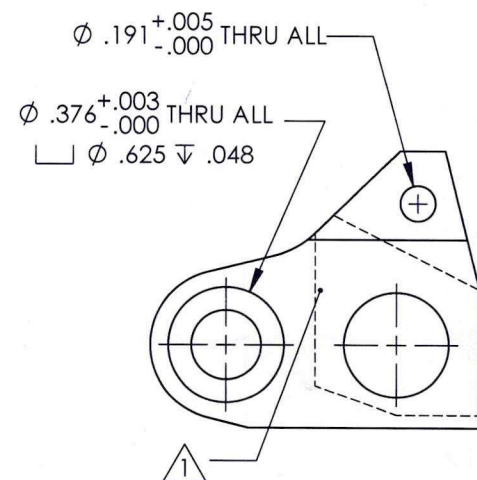
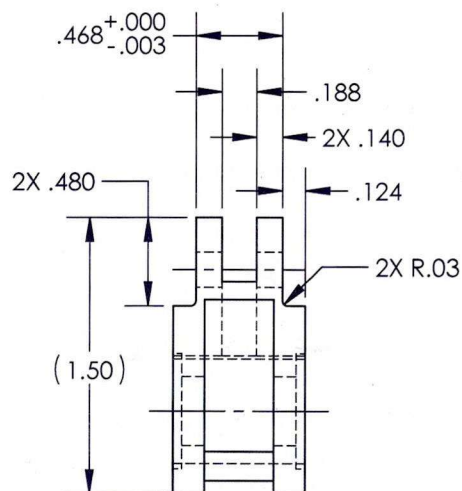
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8		AS DRAWN BY CANAM.	9/11/2012	RJC	
9		CH'D Ø.564 TO Ø.566 & Ø.189 TO Ø.191	10/30/2012	JAG	
10	14-0126	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED MACHINE ENGRAVE NOTE. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	8/13/2014	DPD	RW



SECTION A-A



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 191777 MWS
190308

NOTE:

1 MACHINE ENGRAVE BATCH NUMBER.

DART AEROSPACE	
TITLE LATCH	
DWG NO. C45-3-6	REV 10
MATL 17-4 SS	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 5/14/1997
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C45-3-6	1	LATCH	17-4 SS	3/4 X 1-1/2 X 2

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S165714



Part: C45-3-6
Job No: 191777
Serial No/Batch: S165714
Revision: 10
Inspector:
Exp Date:
Instructions:

Date: 03/25/19

DART AEROSPACE LTD		Work Order: C45-3-6
Description: Latch		Part Number: 141771
Inspection Dwg: C45-3-6 Rev: X10		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.715	±.005	0.716	✓		micrometer	
0.375	±.005	0.371	✓		Vernier	Should be .375±.005
0.170	±.005	0.172	✓		"	
0.030	±.010	.30	✓			
63°	±1/2°	63°	✓			
.766	±.005	0.766	✓		vern + Pins	
1.05	±.010	1.0485	✓		"	
.26	±.010	.26	✓			*
.115	±.005	.115	✓			*
.02	±.010	0.02	✓			*
44°	±1/2°	44°	✓			*
2.41	±.010	2.410	✓			*
14°	±1/2°	14°	✓			*
1.33	±.010	1.329	✓			
0.920	±.005	0.9155	✓			
.40	±.010	.408	✓			
.44	±.010	0.445	✓			
Ø.566	±.001	0.565	✓		P.in	
0.468	±.005	0.4715	✓		Heigh gage	
0.468	±.005	0.467	✓		P.in	
0.144	±.005	0.143	✓		P.in	
0.140	±0.005	0.140	✓		Vernier	
0.124	±0.005	0.123	✓		H gage	
2.03	±0.010	2.03	✓		R gage	
1.50	±0.010	1.502	✓		H gage	
Ø.141	±.005	0.143	✓		P.in	
Ø.376	±.005	0.374	✓		P.in	
0.625	±.005	0.625	✓		Vernier	
0.048	±.005	0.0475	✓		H gage	

Measured by: JBD	Checked by: B.E	QC Inspector:
Date: 19/04/06	Date: 19-04-06	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	